

Date: Wednesday, 06/09/2006 11:04:20 AM  
User: Linda Lacelle

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GPS RECEIVER HOUSING
Job Number : 28416	
Estimate Number : 12516	
P.O. Number : NIA	Part Number : D3514041
This Issue : 06/09/2006 S.O. No. : NIA	Drawing Number : UNDER REVIEW <i>E 06.09.05</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : NIA Type : SMALL /MED FAB	Drawing Revision : N/A
Previous Run : NIA	Material : NIA
Written By : <i>CE</i>	Due Date : 13/09/2006 Qty: 1 Um: Each
Checked & Approved By : _____	
Comment : Est Rev:A New Issue 06-08-30 EC	

Additional Product

# PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D35141	BOX TOP (BOTTOM MOUNTED)
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
BOX TOP (BOTTOM MOUNTED)  
Batch: *B28359*

*CB 07.03.08*

2.0	D35145	BOX BOTTOM (BOTTOM MOUNTED)
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
BOX BOTTOM (BOTTOM MOUNTED)  
Batch: *B28357*

*CB 07.03.08*

3.0	D35149	HOOD
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
HOOD  
Batch: *B28358*

*CB 07.03.08*

4.0	D3524041	UPPER AND LOWER PLATE
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
UPPER AND LOWER PLATE  
Batch: *00053A*

*CB 07.03.08*

5.0	MS21072L06	ANCHOR NUT
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
ANCHOR NUT  
Batch: *M10760*

*SB 07/03/08*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 06/09/2006 11:04:20 AM  
User: Linda Lacelle

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GPS RECEIVER HOUSING

Job Number: 28416

Part Number: D3514041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS20426AD34

RIVET



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

RIVET

Batch: M19099

SB 07/03/08

7.0

MS20426AD45

Rivet



Comment: Qty.: 11.0000 Each(s)/Unit Total: 11.0000 Each(s)

Rivet

Batch: M4067

SB 07/03/08

8.0

MS20426AD48

RIVET



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

RIVET

Batch: M18136

SB 07/03/08

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D3514

SB 07/03/08

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

FE 07.03.08

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

not needed  
For testing  
CB

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

not needed  
For testing  
CB

13.0

D35211

MISSING

BALL



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

BALL

Batch: 624532

28359

CB 07.03.08

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 06/09/2006 11:04:20 AM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GPS RECEIVER HOUSING

Job Number: 28416

Part Number: D3514041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

D35221



GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 16283607

15.0

D35231



LEG



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

LEG

Batch: 60053A

16.0

D35241



LOWER PLATE



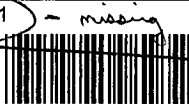
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

LOWER PLATE

Batch: 60053A

17.0

D35261



RUBBER SEAL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

RUBBER SEAL

Batch:

not needed  
for testing  
CB

18.0

AN316A



Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: 101884

CB 07.03.08

19.0

AN936B10



WASHER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WASHER

Batch: 101760

CB 07.03.08

20.0

AN960JD10



Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

Batch: 100274

CB 07.03.08

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/27/24  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 06/09/2006 11:04:20 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GPS RECEIVER HOUSING

Job Number: 28416

Part Number: D3514041

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

MS24693S27 29 CB 07.03.08

SCREW



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

SCREW

Batch: M102147

CB 07.03.08

22.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D3514

23.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

N/A  
prototype  
CB

25.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: Inspection Level 21

(1)

107/07/04

Job Completion



Part went to HAI. Part not approved and not airworthy.  
CB 07.07.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



# PRELIMINARY ISSUE

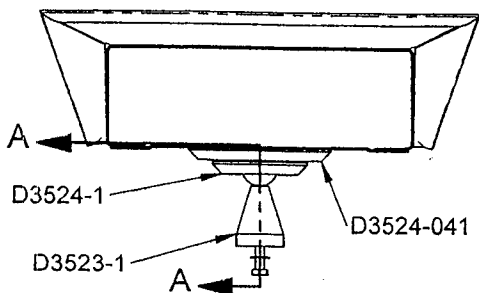
Package  
# 3

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3514	REV. A SHEET 1 OF 7
DATE 06.05.03		TITLE GPS RECEIVER HOUSING	SCALE 1:4
A	06.05.03	NEW ISSUE	

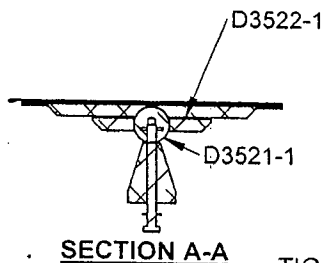
UNDER REVIEW

06.08.22 CB

prototype

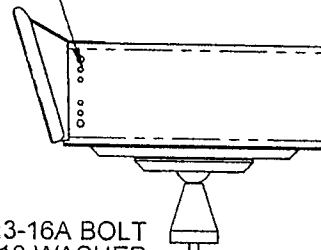


MS21072-06 ANCHOR NUT (1)  
MS20426AD3-4 RIVETS (2)  
(4 PLACES)



SECTION A-A

AN3-16A BOLT  
AN960JD10 WASHER  
AN936-B10 WASHER  
TIGHTEN TO SNUG FIT ONLY



MS20426AD4-5  
RIVETS (8 PLACES)

4-4  
MS20426AD4-5  
RIVETS (3 PLACES)

D3526-1

D3514-9

4-7  
MS20426AD4-8  
RIVETS (4 PLACES)

## PARTS LIST

QTY.	P/N	DESCRIPTION
X	D3514-041	BOTTOM MOUNTED GPS RECEIVER HOUSING
1 ✓	D3514-1	BOX TOP (BOTTOM MOUNTED) ✓
1 ✓	D3514-5	BOX BOTTOM (BOTTOM MOUNTED) ✓
1 ✓	D3514-9	HOOD ✓
1	D3521-1	BALL - missing
1	D3522-1	GASKET - missing
1	D3523-1	LEG ✓ X
1	D3524-1	LOWER PLATE X workorder, not called up ✓
1 ✓	D3524-041	UPPER PLATE ASSEMBLY ✓ X no workorder, called up
1	D3526-1	RUBBER SEAL missing
1	AN3-16A	BOLT missing
1	AN936-B10	WASHER missing
1	AN960JD10	WASHER missing
8 ✓	MS20426AD3-4	RIVET M19099
11 ✓	MS20426AD4-5	RIVET M4067
4 ✓	MS20426AD4-8	RIVET M18136
4 ✓	MS21072L06	ANCHOR NUT M10760
4	MS24693-S27	SCREWS missing

MS24693-S27  
SCREWS (4 PLACES)

## D3514-041 GPS RECEIVER HOUSING (BOTTOM MOUNTED)

### NOTE:

1) POWDER COAT ASSEMBLY OF D3514-1, D3514-5, D3514-9, D3524-041 AND MS21072-06 BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3.

2) INSTALL D3521-1, D3522-1, D3523-1, D3524-1 AND D3526-1 AFTER PAINT

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